

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021125**Date Inspected:** 31-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 12AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3F position of weld joint SEG3004Y-122 located on Cross Beam side Edge Panel at PP110. The welder is identified as 066261. ZPMC Quality Control (QC) is identified as Wu Shi Gao. The welding variables recorded by QC appeared to comply with the WPS B-P-2113- FCM-1. See attached photograph Pic_001.

OBG Segment 12AW

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) on PP109 to Bottom Panel welds.

Bay 16/ Steel Barriers

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 1G position of W5-SB1D-012 Steel Barrier internals weld # W5-SB1D-012-055. The welder is identified as 067765. ZPMC Quality Control (QC) is identified as Guo Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-U4b-F.

OBG Segment 12BE

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) on Bike Path side Longitudinal Diaphragm to Bottom Panel weld.

Bay 19 /OBG Bike Path

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG Bike Path as per ZPMC notification # 07182 items # 16.

The weld designations reviewed are as follows:

BK004A2-003- 013, 021, 002 and 008



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By: Gade,Ramesh

Quality Assurance Inspector

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Reviewed By: McClendon, Timothy

QA Reviewer